

Date: Friday, 23/05/2008 9:56:58 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 39449		
Estimate Number	: 11073		
P.O. Number	:	Part Number	: D31373
This Issue	: 23/05/2008 S.O. No. :	Drawing Number	: D3137 REV. <i>0 E</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: <i>0 E</i> <i>20/05/23</i>
Previous Run	: 37657	Material	:
Written By	:	Due Date	: 30/05/2008 Qty: <i>100</i> Um: <i>20</i> Each
Checked & Approved By	: <i>JUL 08.5.23</i>		
Comment	: Est Rev:A 02.05.29 New Issue NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MDELRLNB075X1250	Delrin Bar
-----	------------------	------------



Comment: Qty.: 0.0831 f(s)/Unit Total : 1.6611 f(s)
 Matl:Black Delrin bar 1.250" x .750"
 (ref DART spec. M-DELRIN-B)
 Batch: *M14535*

ml 08/06/22

105

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut Blanks.Blank size: 1.250" x .750" x .950" long

ml 08/06/22

105

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA242 & Dwg D3137

2-Deburr

JL 08/06/25

(103)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/06/25

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8/08/06/25/ (103)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:56:58 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 39449

Part Number: D31373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



103

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 238

8/6/26

SD

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/01 98

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JUD 08-6-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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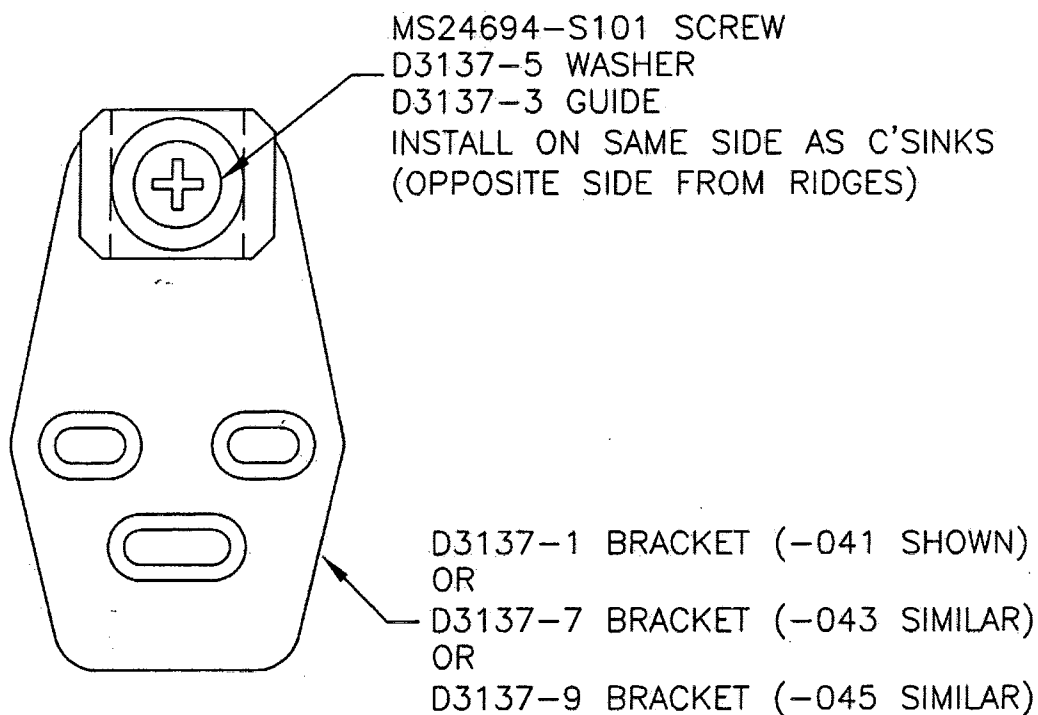
NOTE: Date & initial all entries



DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	
E	05.11.23	ADD -045	

RELEASED

05.12.09



D3137-041 BRACKET ASSEMBLY (SHOWN)
D3137-043 BRACKET ASSEMBLY (SIMILAR)
D3137-045 BRACKET ASSEMBLY (SIMILAR)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

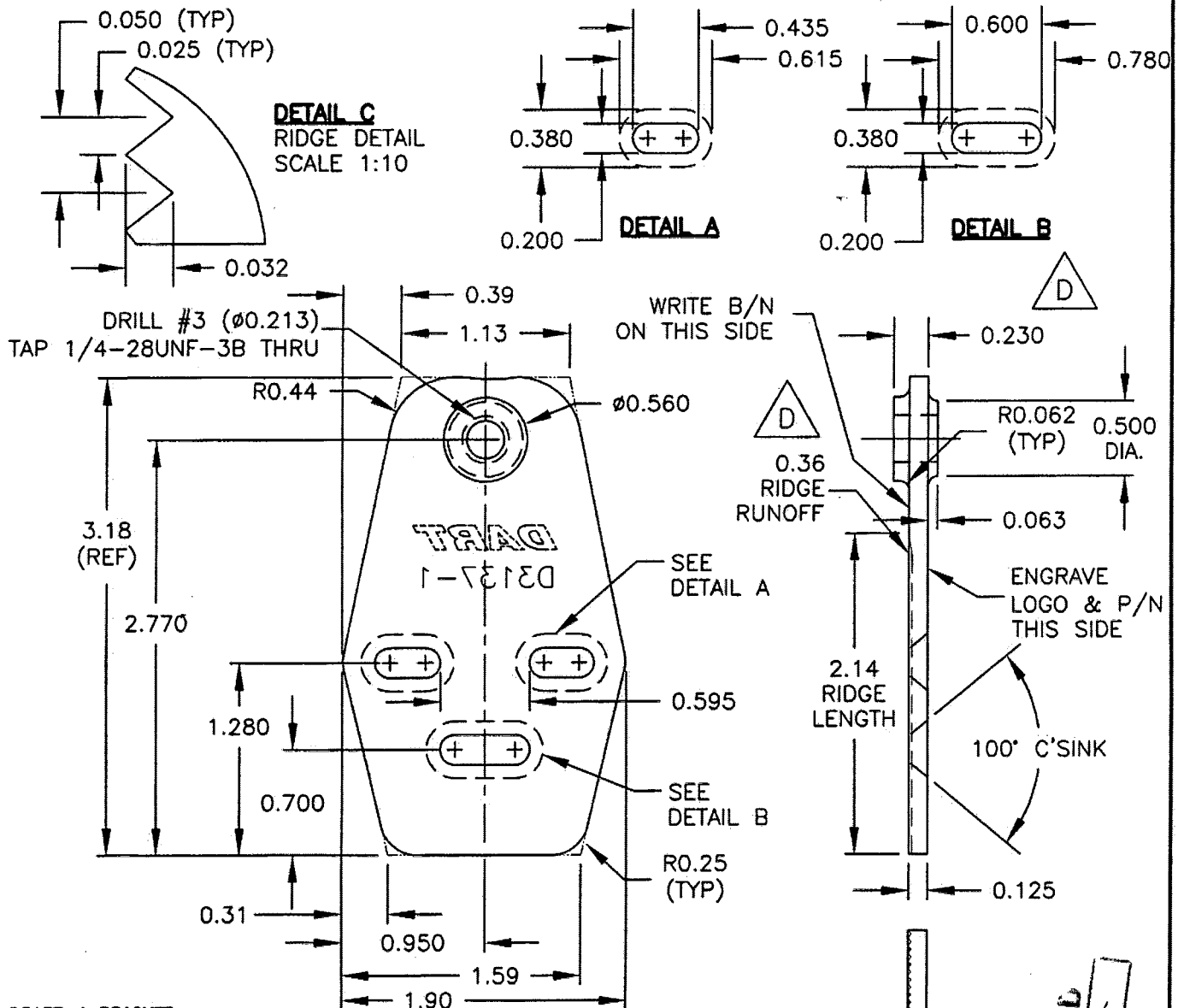
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3137-1 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

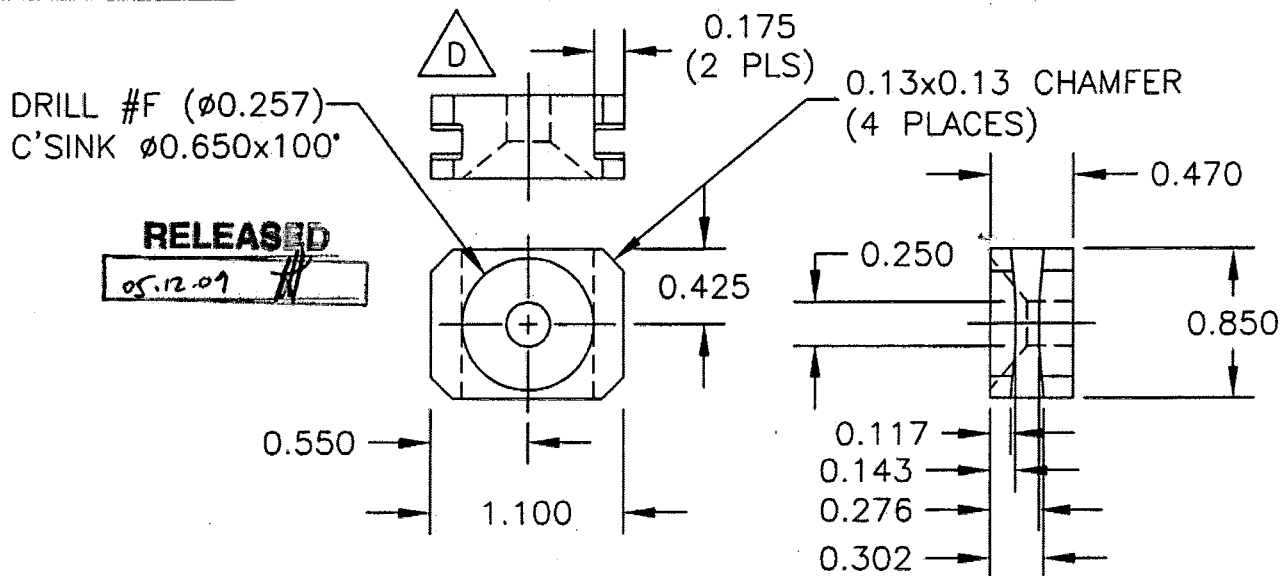
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

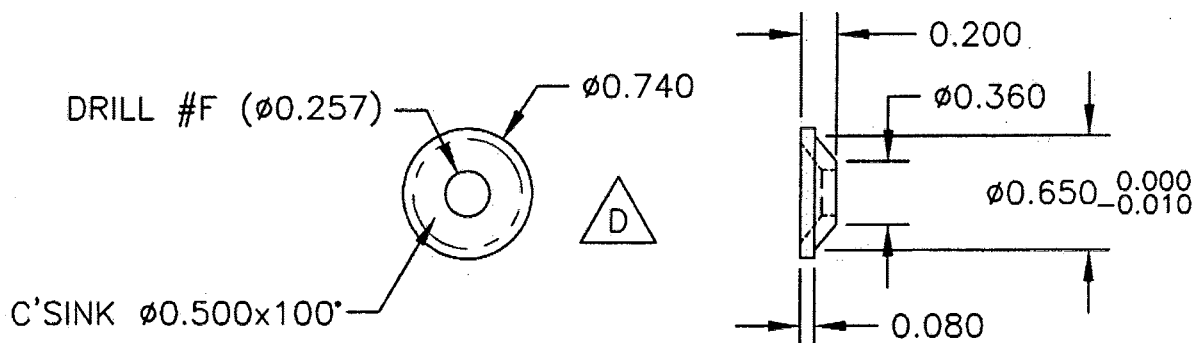


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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1



D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015



D3137-5 WASHER

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

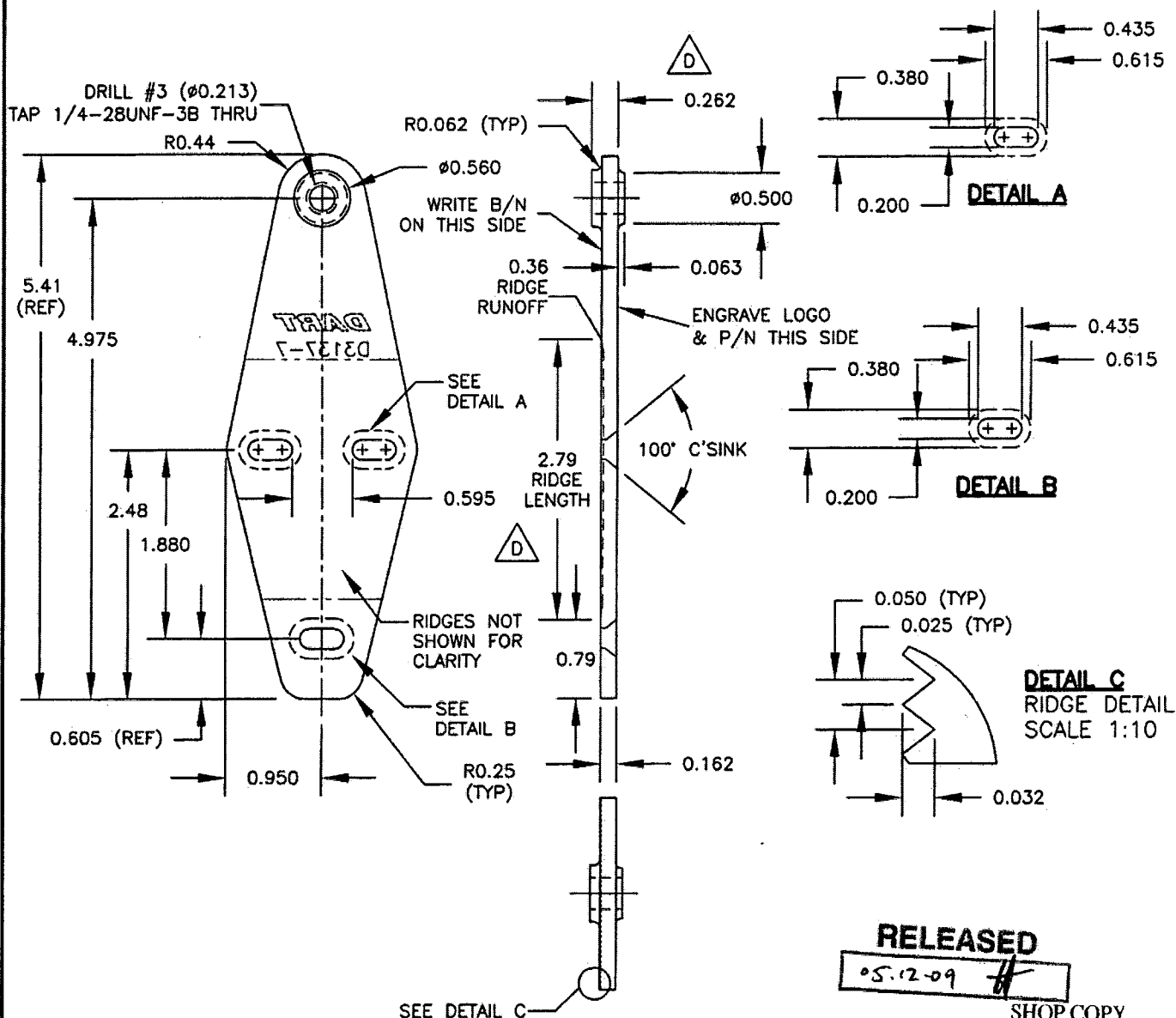
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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 05.11.23		TITLE BRACKET ASSEMBLY SCALE 2:3	



D3137-7 BRACKET:

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

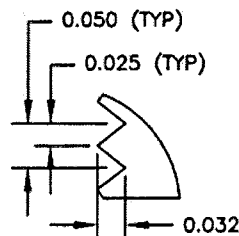
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

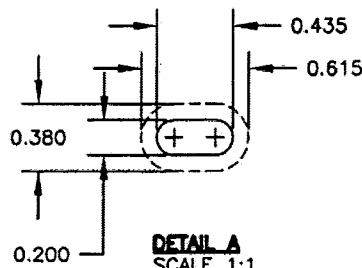
NOTE: Date & initial all entries

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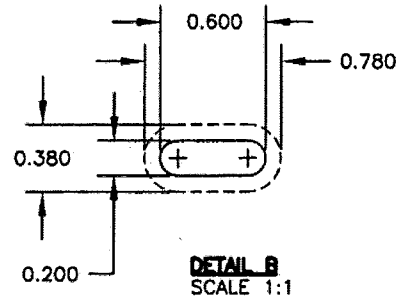
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:2



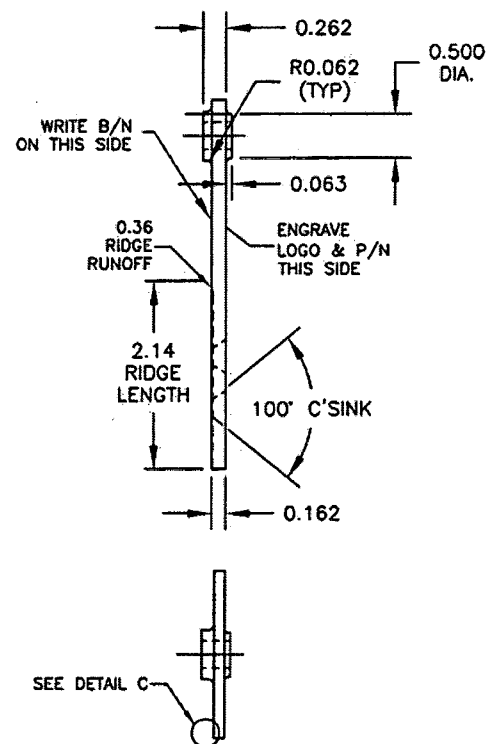
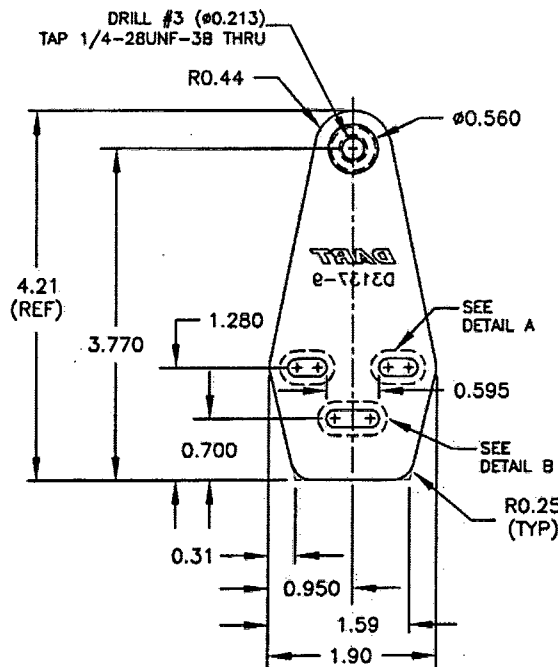
DETAIL C
RIDGE DETAIL
SCALE 1:20



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1



D3137-2 BRACKET:

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries